| Work Order ID 68952 Tuesday, April 26, 2011 10:44:29 AM | | | | 7 - 2 | | | | • | Page 1 |
|--|--------------------------|-------------------------|-----------------------|--------|--------------|---------------|------------------|------------------|----------------|
| Item ID: D3490-3 Revision ID: Item Name: Cross Bolt Spacer | | Accept | | | | | Setup Star | \$ 88 | |
| Start Date: 4/26/2011 Start Qty: 60.00 Required Date: 5/2/2011 Req'd Qty: 60.00 Reference: | | | Cust Item I Customer: | D: | | | , | 1 /98211182 8 | |
| Approvals: Process Plan: QC: | Date: | Tooling: SPC (Y/N): | | ite: | | • | Run Star Stop | | |
| Sequence ID/ Operation Work Center ID Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr Revision Nbr | | | | | | | | * | |
| D3490 Rev A | | | | | | | | • | |
| FOLIO RI DWG RE | AS PER FOLIO FA629 & DWO | 0.00 0.00 G D3490 | /2 | | * | 64 | D. | | |
| QC2- Inspect parts off Wemo Quality Control | machine FAI/FAIB | 0.00 | | | | 64 | 6_ | | |
| | < y | 1US/2 | | | | · - | | | |
| 120 QC8- Inspect parts - so QC Memo Quality Control | econd check | 0.00 | 11/05/03 | | | | | | |

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| W/O: | | | WC | RK ORDER CHANG | ES | | | | | |
|---|------|-------------------|----------------------|------------------------------|--------|-------------|--------|-------------------------------|--------------------------|--------------|
| DATE | STEP | PRO | OCEDURE CHA | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No | : | PAR #: | Fault Cate | gory: | _ NCR | : Yes I | No DQ | A: | Date: | |
| | Res | solution: | Dispositio | n: | QA: | N/C Clo | sed: | | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORM | ANCE | (NCR |) | | | |
| | | Description of NC | | Corrective Action Sect | tion B | | Verifi | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | on C | Chief Eng | QC Inspector |
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Work Order ID 68952

Tuesday, April 26, 2011 10:44:30 AM



Page 2

Item ID:

D3490-3

Accept



Setup Start

Stop



Revision ID:

Item Name:

Cross Bolt Spacer

Start Date:

4/26/2011

Start Oty: 60.00

Required Date: 5/2/2011

Req'd Qty: 60.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date: Date:

Tooling: SPC (Y/N):

Date: Date:

Tool # Plan

Code

Start Run

Reject

Qty

Stop

Sequence ID/

Work Center ID

130

Packaging

Memo

Set Up/ Run Hours

0.00

0.00

Accept

Qty

Reject Number

Insp. Stamp

Packaging

Identify as per dwg & Stock Location:

STOCK IN SKIDTUBE CELL

140

QC21- Final Inspection - Work Order Release

0.00

QC Quality Control Memo

0.00

| W/O: | | | W | ORK ORDER CHANG | FS | | | | | |
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| DATE | STEP | PRO | OCEDURE CH | | | Зу | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cat | egory: | NCR: | Yes N | lo DQ | A: | Date: _ | |
| | R | esolution: | Dispositi | on: | QA: N | I/C Clo | sed: | | Date: _ | |
| ʹNCR: ~ | | \ | WORK ORE | DER NON-CONFORM | ANCE (| NCR) | | | | |
| DATE | CTED | Description of NC | | | tion B | | Verific | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | ion C | Chief Eng | QC Inspector |
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Picklist Print

Tuesday, April 26, 2011 10:44:36 AM

Work Order ID: 68952

Parent Item:

D3490-3

Parent Item Name: Cross Bolt Spacer



Start Date: 4/26/2011

Required Date: 5/2/2011

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|----------------|--------------|---------------|----------------|--------|
| M6061T6R0.750 | | Purchased | No | | | 100 | f | 101.4130 | 0,266 | 16.8 | | | |
| | | | | | | | | | < | Ni | 1115 | /2 | |

6061-T6 Round Bar .750"

| <u>Location</u> | Loc Qtv | Loc Code | |
|-----------------|---------|----------|---|
| MAT013 | 101.413 | | *************************************** |
| 112442 | 0.796 | | |
| 116406 | 0.617 | | |
| 117481 | 100 | | 17 |
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Page 1

| W/O: | • | | W | ORK ORDER CHAN | GES | | | | | |
|---------|------|-------------------|----------------------|------------------------------|----------|----------------|----------|-------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | E | Зу | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cat | egory: | NCR: | Yes N | o DQA | : | Date: | |
| | Res | solution: | Dispositi | on: | QA: N | /C Clos | sed: | | Date: | |
| NCR: | | · | WORK ORE | DER NON-CONFORM | MANCE (| NCR) | | | | |
| DATE | STEP | Description of NC | | | ection B | | Verifica | ation | Approval | Approval |
| | SIEF | Section A | Initial Chief Eng | Action Description Chief Eng | 1 ; | Sign & Date | Sectio | | Chief Eng | QC Inspector |
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| DART AEROSPACE LTD | Work Order: | 18952 |
|-------------------------------|--------------|-------------|
| Description: Crossbolt Spacer | Part Number: | D3490-3 |
| Inspection Dwg: D3490 Rev: A | | Page 1 of 1 |

| | FIRS | T ARTICLE IN | NSPECTI | ON CHE | ECKLIST | | |
|----------------------|-----------------|---------------------|----------|--------|-----------|------------|---|
| |) | First Arti | cle | Prot | otype | | |
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method o | | mments |
| 3.085 | +0.030/-0.000 | 3,103 | | | 8/-9 | | |
| 0.080 | +/-0.010 | -016 | | | | | |
| Ø0.591 | +0.008/-0.001 | 2396 | | | | | |
| 0.050 x 45° | +/-0.010 x 0.5° | OSOX45° | | | | | |
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| Measured by: | 12 | Audited by: | N | | Prototype | Approval: | N/A |
| Date: | 11/5/2 | Date: | 11/15/13 | | | Date: | N/A |
| | | | | | | L | |
| Rev Date | Change | | | | | Revised by | Approved |

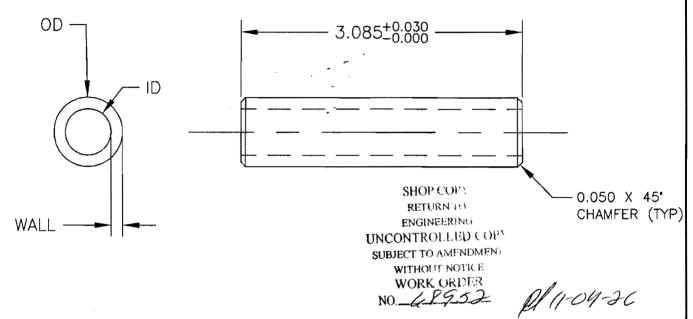
| | Kev | Date | Change | Revised by | Appro | V.eya |
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| 1 | A | 06.10.27 | New Issue | KJ/JLM OX | | 7 |
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| DATE | STEP | PRO | CEDURE CHA | NGE | Ву | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR: Y | es N | o DQ A | ۸: | Date: | |
| | | esolution: | | | | | | | | |
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| DATE | CTED | Description of NC | | Corrective Action Section | | | Verific | | Approval | Approval |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Section Action Description Chief Eng | Sig | n & ate | Verific Section | | Approval Chief Eng | Approval QC Inspector |
| DATE | STEP | Description of NC Section A | | Action Description | Sig | | | | Approval Chief Eng | Approval QC Inspector |
| DATE | STEP | Description of NC Section A | | Action Description | Sig | | | | Approval Chief Eng | Approval QC Inspector |
| DATE | STEP | Description of NC Section A | | Action Description | Sig | | | | Approval Chief Eng | Approval QC Inspector |
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|-------|------|------------|---------------------------------|------------------------|
| CHECK | ED # | APPROVED 4 | drawing no. D3490 | REV. A SHEET 1 OF 1 |
| DATE | | | TITLE | SCALE |
| 06.0 | 1.04 | | CROSS BOLT SPACER | NTS |
| Α | | 06.01.04 | NEW ISSUE | |



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

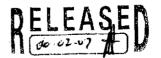
| PART NUMBER | OD | WALL | ID (REF) | MATERIAL SPEC |
|----------------|-------|-------|-------------|--------------------|
| D3490-1 | 0.500 | 0.049 | 0.402 | M6061T6T0.500W.049 |
| D3490-3 | 0.750 | 0.080 | 0.591 | M6061T6R0.750 |
| D3490-5 | 0.313 | 0.058 | 0.197 | M6061T6T0.313W.058 |

D3490-1/-3/-5 CROSS BOLT SPACER

MATERIAL: 1) ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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| W/O: | | | W | ORK ORDER CHANGES | | | | | | |
|----------|------|---------------------------------------|-----------------------------|---------------------------------------|--------------|--------|------------------|-------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| DATE | STEP | Description of NC | Corrective Action Section B | | | | | Approval | Approval | |
| DATE | STEP | Description of NC | 1 | · · · · · · · · · · · · · · · · · · · | | | cation | Approval | Approval | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | & Sect | cation tion C | Chief Eng | | |
| DATE | STEP | Description of NC Section A | | Action Description | Sign | & Sect | | Approval Chief Eng | Approval | |
| DATE | STEP | Description of NC Section A | | Action Description | Sign | & Sect | tion C | Chief Eng | Approval | |
| DATE | STEP | Description of NC Section A | | Action Description | Sign | & Sect | | Chief Eng | Approval | |
| DATE | STEP | Section A | | Action Description | Sign | & Sect | tion C | Chief Eng | Approval | |
| DATE | STEP | Section A | | Action Description | Sign | & Sect | tion C | Chief Eng | Approval | |
| DATE | STEP | Section A | | Action Description | Sign | & Sect | tion C | Chief Eng | Approval | |
| DATE | STEP | Section A | | Action Description | Sign | & Sect | tion C | Chief Eng | Approval | |
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